Date:

Tuesday, 1/3/2006 4:20:11 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 25373

: 10725 **Estimate Number**

:NIA P.O. Number

: 1/3/2006 This Issue Prsht Rev.

: NC : NIA : 24844

S.O. No. : N/A

: MACHINED PARTS

Part Number

Drawing Name

: D2652

: BUSHING

Drawing Number

: D2652 REV A

Project Number Drawing Revision

: NIA

: N/A

Material : 1/21/2006 **Due Date**

Qty:

200 Um: Each

Written By

Comment

First Issue

Previous Run

Checked & Approved By

Now machined in house.

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

NG

303 Round Bar 0.500"



M303R0500

Comment: Qty.:

0.0578 f(s)/Unit Total: 11.5500 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: M19488

06/02/06

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

06/02/06

J38

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 50

Job Completion



CLOG102107

Page 1

Form: rprocess

Dart Aerospace Ltd	D	art	Aer	rost	oace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				1						

Part No:		_PAR #:	Fault Category:	NCR: Yes (No) DQA:	Date:	<u>06/02/08</u>
	*			QA: N/C Closed: _	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annexal		
DATE STEP		Section A	Initial Chief Eng			Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25313
Description: Bushing	Part Number:	D2652
-		
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
0.600	+/-0.010	0,599						
0.060	+/-0.005	0.058						
Ø0.305	-0.002/+0.000	Ø 0.3038						
Ø0.191	+0.005/-0.000	\$0.192						
Ø0.500	+/-0.010	80.497						
0.030 x 20°	+/-0.010	0.027x20°						
R0.010	+0.010/-0.000	R0.010						
						,		
•						,		
<u>.</u>								

Measured by:	The	Audited by:	Ep	Prototype Approval:	N/A
Date:	06/02/06	Date:	06/02/06	Date:	N/A.

Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	

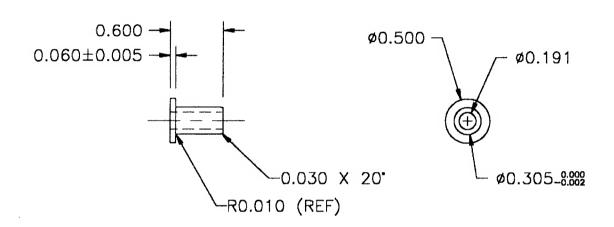
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S. Carrier		





DESIGN	DRAWN BY	DART AEROSPACE USA FAIRCHILD INTERNATIONAL AIRPORT,		IC.	
CHECKED	APPROVED 0100	DRAWING NO. D2652	SHEET	REV.	
DATE	IV-PV	TITLE		SCA	Œ
97:03:25		BUSHING			1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THO WASHINGTON

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NO 25373

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